

Work Order ID 72197

Wednesday, July 20, 2011 7:49:09 AM



Page 1

Item ID:	D3290-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Window Assembly					
Start Date:	7/19/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	7/26/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-07-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3290	DEO Rev C1								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3290 (use prog. for D3290-1)								
661.663	Dwg Rev: <u>4</u>								
	Prog Rev: <u>4</u>								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

B11-8-3

(6)

B11-8-3

(46)

Suloslos

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start



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Stop



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Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 0 11/08/05

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1118439
START TIME: 9:00am
OVEN TEMPERATURE: 370°F
FINISH TIME: 9:30am

6 0 11/08/08

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6x 0 M 11/08/08

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Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per Dwg D3290
Clean D3290-041 and place in plastic wrap

x6

DL
4/09/12

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DL
4/09/12

x6

180



Packaging

Packaging

Identify as per dwg & Stock Location: ST219

0.00

Memo

0.00

DL
SP 11-09-13

W/O:		WORK ORDER CHANGES					
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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

R11-09-13
(6)

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Picklist Print

Wednesday, July 20, 2011 7:49:16 AM

Page 1

Work Order ID: 72197

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly




Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B005.05.25 Added Step 11 KJ/JLM
 IPP C006.05.09 Ecn 798 EC
 IPP Rev:D Now on Waterjet 06-06-16 JLM
 IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	211.4456	3.75	23.68421			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>MAT021</div> <div>211.4455684</div> <div></div> </div>													
<div> <div>116308</div> <div>26.9755684</div> <div></div> </div>													
<div> <div>117285</div> <div>184.47</div> <div></div> </div>													
D2126  Seal		Manufactured	No			160	f	351.6900	6.5	39			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST405</div> <div>351.69</div> <div></div> </div>													
<div> <div>57106</div> <div>4</div> <div></div> </div>													
<div> <div>68336</div> <div>347.69</div> <div></div> </div>													
(D2126-0780) cut qty (1) at 78.00" as per dwg ***per kit***													
D3290-3  Window		Manufactured	No			160	Each	6.0000	1	6			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST221</div> <div>6</div> <div></div> </div>													
<div> <div>69556</div> <div>6</div> <div></div> </div>													

B11-8-3

(6)

117285

DL
11/09/12

23.68421 PL

DL
11/09/12

6

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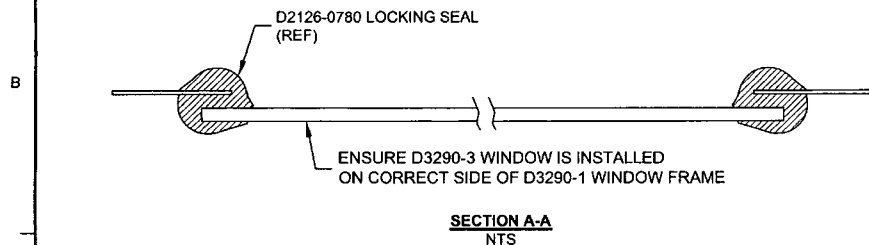
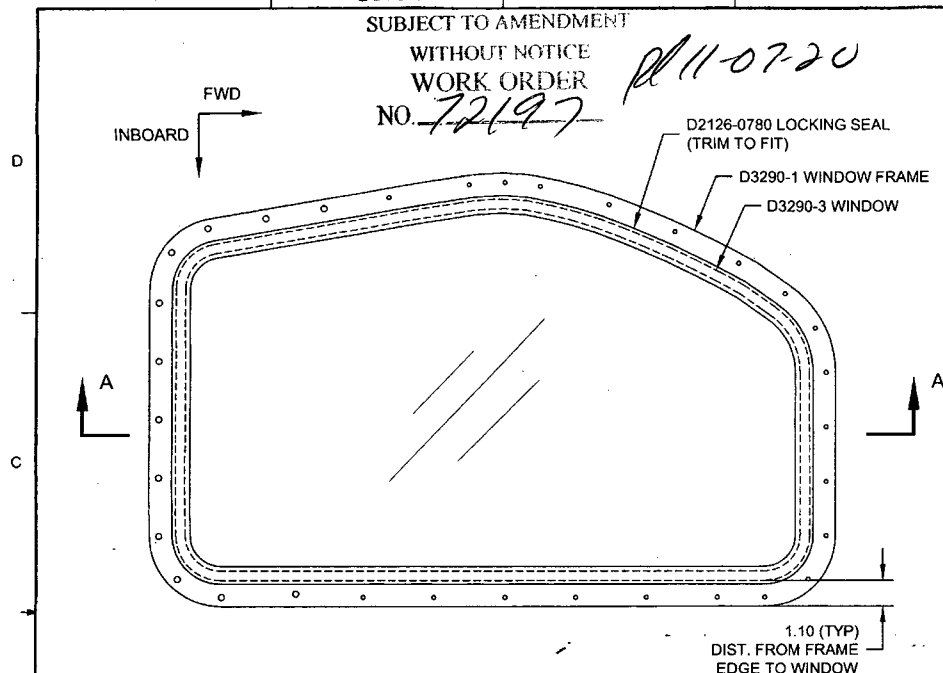
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. *72197*

11-07-20

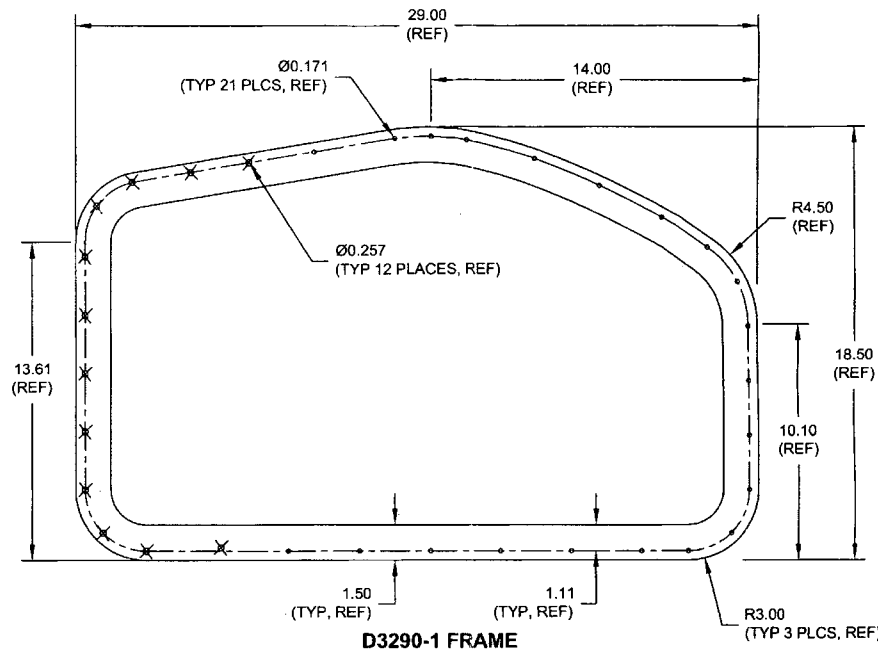


D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24
DEO ATTACHED

UNDER REVIEW

4/29/18
6/12/19

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3290
REV. C
SHEET 1 OF 2
TITLE
REPLACEMENT WINDOW ASSEMBLY
SCALE 1:5

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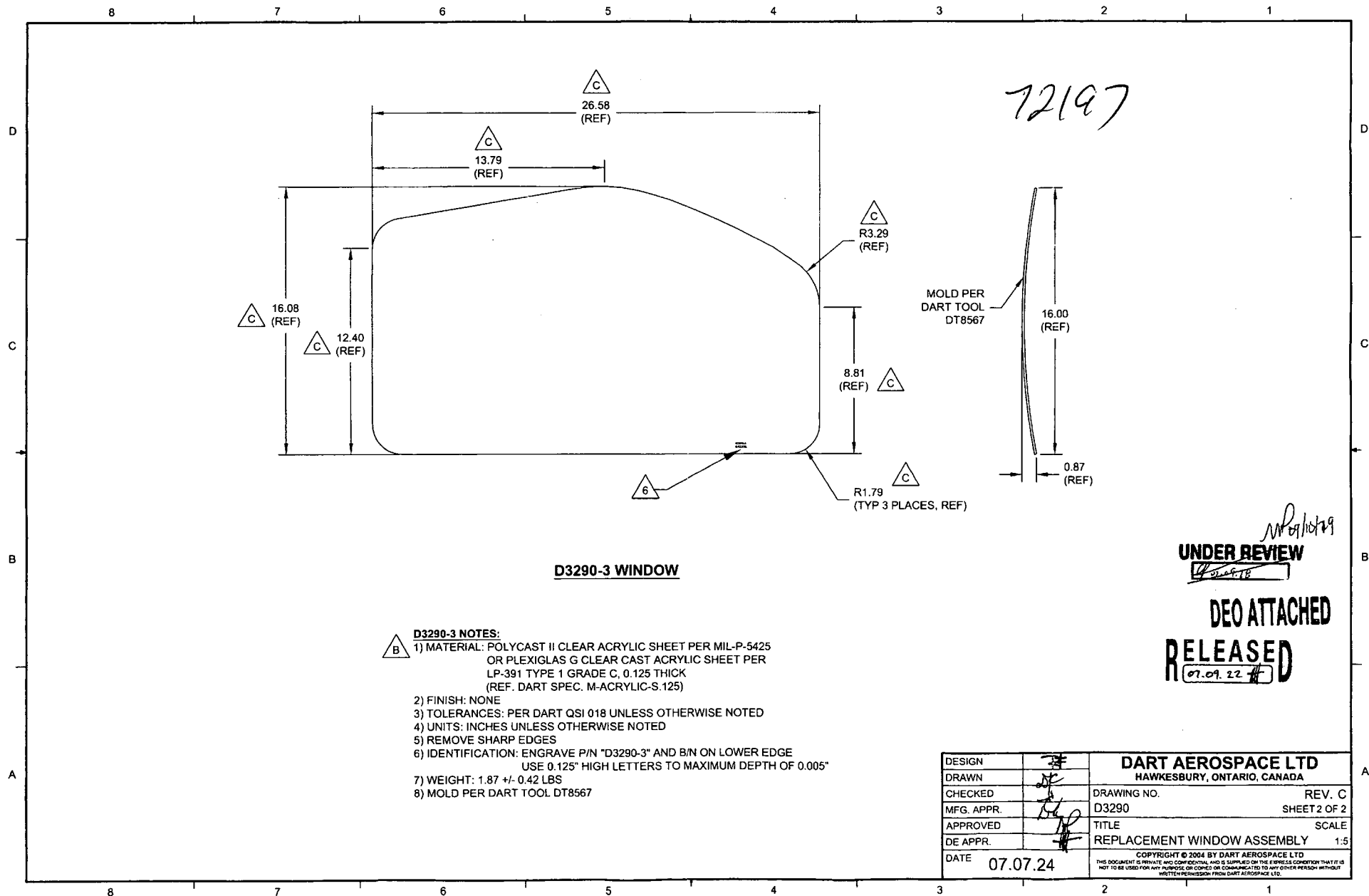
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M. J. H. 12/29

UNDER REVIEW
[Signature]
DEO ATTACHED
RELEASED
[Signature]

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>GP</i>	CHECKED <i>b</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>	DE APPR. <i>#</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

72197

RELEASED
 2009 -10- 09
WMP

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		<div data-bbox="315 893 735 1104"> </div>						

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